

Date: Wednesday, 5/9/2007 8:16:13 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32247
 Estimate Number : 12788
 P.O. Number :
 This Issue : 5/9/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : SMALL / MED FAB
 Previous Run : 31398

Drawing Name : WEARSHOE
 Part Number : D356413
 Drawing Number : D3564 UNDER REVIEW
 Project Number : WP0002
 Drawing Revision : A
 Material :
 Due Date : 5/16/2007

KEEP
 IN ENG'G
 LAB
 RB
 07.05.05

Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est Rev:A New Issue 07-03-08 ec

Additional Product

FOR ENGINEERING USE ONLY

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.1785 sf(s)/Unit Total: 0.3570 sf(s)
 M304S16GA Stainless steel sheet 0.063" thick
 Batch: *M19052*

SAD 07/05/05

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3564 *Prog in Preliminary*
 Dwg Rev: *U Review*
 Prog Rev: *U Review/Prel*

SAD 07/05/09

(2)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/09

(2)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

[Signature]
07/05/09
(2)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 Deburr if necessary
 Form on Brake as per Dwg D3564 using Jigs DT and DT

SAD 07/05/09

(2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32247

Part Number: D356413

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

07.06.05

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

N/A No Powder Coat Required

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/05

Job Completion



Job/Project Number:

00082

Design Engineer/Project Manager Signature:

PH

Date: 07.05.03

Design Manager Signature:

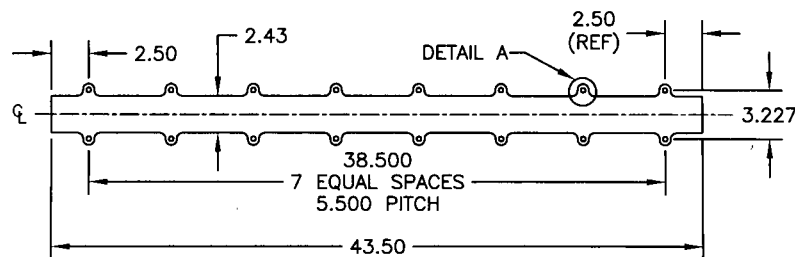
N/A

Date: _____

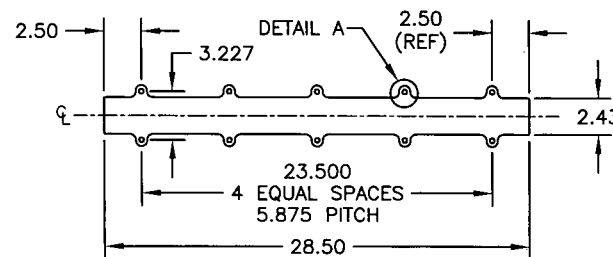
PROTOTYPE REQUEST FORM

Item	Part Number	Drawing Number Date	Qty	Material Cert Required (Y/N)	Due Date	Complete Date	Comments
1	D3564-13	D3564 Rev C PRELIMINARY	1	N	07.05.09	07.06.05	PRELIMINARY ONLY, RETURN PARTS TO P. HUM

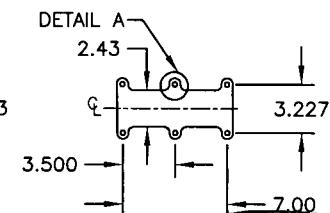
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
PH 07-05.03



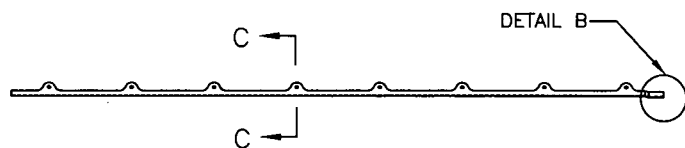
D3564-5F FLAT PATTERN



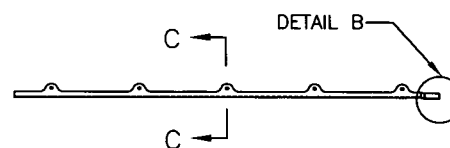
D3564-7F FLAT PATTERN



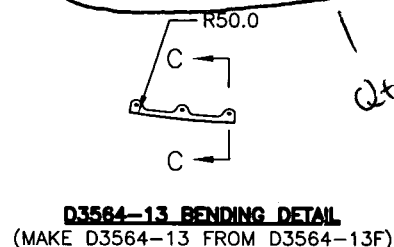
D3564-13F FLAT PATTERN



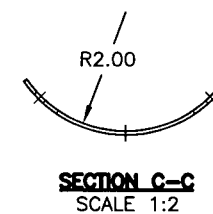
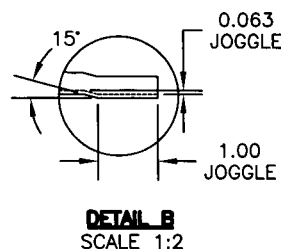
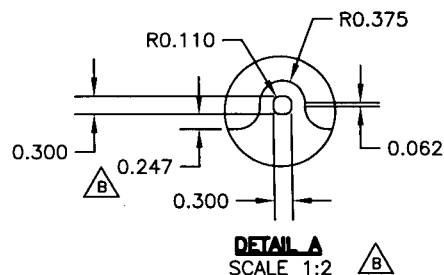
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



Material

HISI 304/316, 16 GAUGE (0.063 THICK)
(REF M304S16GA)

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		DATE 07.04.17		TITLE WEARSHOE	SCALE 1:8

DART AEROSPACE LTD		Work Order: 32247
Description: WEAR SHOE		Part Number: D356413
Inspection Dwg: D356413 Rev: UNDER Review		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 2.43	+/-0.030	2.43	✓		Vern	
B 3.500	+/-0.010	3.499	✓		Vern	
C 7.00	+/-0.030	7.00	✓		Vern	
D 3.227	+/-0.010	3.222	✓		Vern	
E 0.300	+/-0.010	0.299	✓		Vern	
F 0.300	+/-0.010	0.302	✓		Vern	
G 0.063	+/-0.010	0.058	✓		Vern	
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD	Audited by: RH	Prototype Approval:	N/A
Date: 07/05/09	Date: 07.05.09	Date:	N/A
Rev	Date	Change	Revised by
		SC 07.05.09	KJ/RF
		New Issue	Approved